

Work Order ID 64951

Tuesday, January 04, 2011 3:07:22 PM



Page 1

Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *11-01-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4168	A								
IIN-D350-636	H								
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy blue file and type labels per PPP D350-636-015 CHG 001								

N/A

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Skidtubes	0.00							
Skidtubes	Memo	0.00				1	0		BE 1/10/07
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168.								
	6- Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.								
	9-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D4168. Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side) and .210" (total of 1 hole per side)								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left
from bending as per QSI 004A/R Aluminum Rod batch: ☐ M11577B

12-Grind welds flush as per Dwg D4168

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/11/01/07

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/01/07

76

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 0 8E11/01/10

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-1-18

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D4168.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D4168.

3- Open float hole to 0.500" (4 per side)

Open wearplate holes to size as per dwg (4 holes per sides)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D4168
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: mil6070 ☐☐☐
exp. date: 09/2011

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1
& QSI004

(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: mil5778

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 11/01/11

BE 11/01/17

mil6577

mil66577

BE 11/01/17

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10-Grind welds flush as per Dwg D4168

11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168

12- C'bore section CG-CG

13- Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

Memo

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

⇒ M 11/01/24

1 0

HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115951

0.00

Powdercoat

Memo

Powder Coating

START TIME: 8:30
OVEN TEMPERATURE: 320
FINISH TIME: 9:00

1 BL 11-01-25

210

QC3- Inspect Part Finish

0.00

⇒ M 11/01/25

1 0

QC

Memo

0.00

Quality Control

✓ Inspect for foreign object per QSI 024

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00

HandFinishing 7 M 11/01/25

0.00

HandFinish

Memo

Hand Finishing

✓ Install inserts as per Dwg D4168

230

0.00

HandFinishing

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168

✓ SIKA FLEX 241

BATCH: 111514

EXP DATE: 11/01

✓ 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: 1114189

✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: 114896

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

Sulau/27



QC

Memo

0.00

Quality Control

(H)

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/1/278

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

Sulau/27

(H)

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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-015								
	Location: _____								
	PPP rev: _____								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

PP 63/37

11/1/27

11/01/28

U 11.01.27

Picklist Print

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Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C42A

Purchased No

230

Each

97.0000

1

1



BOLT



11/16/11

Location

Loc Qty

Loc Code

ST354

97

106176

97

1

D3873-1

Manufactured No

230

Each

273.0000

7

7



Bushing



11/16/12

Location

Loc Qty

Loc Code

ST089

100

64567

100

ST092

170

62197

40

63314

30

64760

100

x7

ST093

3

57615

3

D4154-041

Manufactured No

230

Each

0.0000

1

1



Wearplate Assembly



1362711 (x1) 11/16/12

D4170-1

Manufactured No

230

Each

27.0000

4

4



Bushing



11/16/13

Location

Loc Qty

Loc Code

LG

27

62251

4

62669

1

63322

22

4

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4171-1 Manufactured No

230

Each

11.0000

1

1



Bushing



11/01/20

Location

Loc Qty

Loc Code

ST135

11

62710

11

MS21043-3

Purchased

No

230

Each

1,731.000

5

5



11/01/20

Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1655

112314

1655

NAS1149C0363R

Purchased

No

230

Each

5,568.000

9

9



11/01/20

Washer

Location

Loc Qty

Loc Code

ST297

5568

113524

46

113644

22

113889

500

114742

5000

11/01/20

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased No

230 Each

340.0000 4 4



WASHER



11/01/26

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

300

111819

66

113362

234

x4

AN960JD816

Purchased No

250 Each

105.0000 2 2



1/2" washer, Alum ~~XNAS1144D0816J~~



11/01/26

Location

Loc Qty

Loc Code

ST348

105

106043

105

~~M1105384~~

x2

D2744

Manufactured No

110 Each

32.0000 1 1



Cap



BE 11/01/07

Location

Loc Qty

Loc Code

ST

32

62715

32

1

D2600-3-BENT

Manufactured No

110 Each

14.0000 1 1



Extrusion Bent



BE 11/01/06

Location

Loc Qty

Loc Code

LG

14

61634

4

62764

1

64434

9

1

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Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

170.0000

8

8



Crossbolt Spacer



BE 11/01/13

Location

Loc Qty

Loc Code

LG

170

50281

10

57953

2

59111

10

61844

64

64003

84

8

D2739

Manufactured No

160

Each

13.0000

1

1



350 I Beam



BE 11/01/11

Location

Loc Qty

Loc Code

LG

13

62688

3

64448

10

1

D3490-3

Manufactured No

160

Each

59.0000

4

4



Cross Bolt Spacer



BE 11/01/13

Location

Loc Qty

Loc Code

LG

59

60294

1

62668

6

63556

30

64006

22

4

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Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No

160

Each

89.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

89

59424

3

62450

56

64005

30

ALS4-1032-225

Purchased

No

230

Each

4,124.000

4

4



Insert

Location

Loc Qty

Loc Code

PK011

4124

110768

4124

D3492-041

Manufactured

No

230

Each

97.0000

8

8



Plug Assembly

Location

Loc Qty

Loc Code

FP013

97

59114

1

62210

3

63994

93

AN8C35A

Purchased

No

230

Each

44.0000

1

1



BOLT

Location

Loc Qty

Loc Code

ST346

44

114442

5

115188

13

115960

26

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Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

21.0000

1

1



Blade Fitting Assembly, LH



11/01/26

Location

Loc Qty

Loc Code

FG008

10

62002

10

FP007

2

56052

2

FP18

9

61689

9

X1

AN6C44A

Purchased No

230

Each

79.0000

4

4



BOLT



11/01/26

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

77

111649

2

114653

1

114941

24

115936

50

X4

MS21083C8

Purchased No

230

Each

67.0000

1

1



NUT



11/01/26

Location

Loc Qty

Loc Code

ST303

67

113845

5

114934

3

115594

4

115884

46

116289

9

X7

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Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No

230

Each

201.0000

8

8



Washer



11/01/26

Location

Loc Qty

Loc Code

ST072

201

60755

9

63647

192

AN960C10L Purchased No

230

Each

25.0000

4

4



washer



11/01/26

Location

Loc Qty

Loc Code

ST245

25

107534

25

M116025

X4

D2745 Manufactured No

230

Each

185.0000

8

8



Bushing



11/01/26

Location

Loc Qty

Loc Code

ST023

185

52311

5

59112

4

61988

68

63315

108

AN960C816L Purchased No

230

Each

0.0000

1

1



WASHER XNAS1149C08332R / M114915



(x1) 11/01/26

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Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

230 Each

65.0000 8 8



Plug Assembly

Handwritten: 11/01/26 PTO →

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

63

59117

1

59190

4

63996

58

AN3C6A

Purchased No

230 Each

241.0000 4 4



BOLT

Handwritten: 11/01/26

Location

Loc Qty

Loc Code

ST351

241

111982

166

116419

75

MS21043-6

Purchased No

230 Each

578.0000 4 4



NUT

Handwritten: 11/01/26

Location

Loc Qty

Loc Code

ST301

578

112314

578

D3493-1

Manufactured No

250 Each

16.0000 2 2



Washer

Handwritten: 11/1/27

Location

Loc Qty

Loc Code

ST062

16

61672

16

Handwritten: 2

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Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

67.0000

1

2



Handwritten: 11/01/26

NUT

Location

Loc Qty

Loc Code

ST303

67

113845

5

114934

3

115594

4

115884

46

116289

9

Handwritten: X1

Handwritten: X1

AN8C21A

Purchased

No

250

Each

87.0000

2

2



Handwritten: 11/01/26

BOLT

Location

Loc Qty

Loc Code

ST345

87

113558

1

114653

2

115723

24

116381

60

Handwritten: V2

D2741

Manufactured

No

250

Each

47.0000

1

1



Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

47

60210

12

61341

35

Handwritten: 11/01/25

W/O: 64951		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/26	230	Assemble D3492-043 "Plugs" with NAS1611-013 "O" rings M116582	JH	11/01/26	x8		S 11/6/27
11/01/26	230	Assemble D3492-041 "Plugs" with D2594-3 / M161672 "O" rings	JH	11/01/26	x8		S 11/6/27

Part No: D350-636 015 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

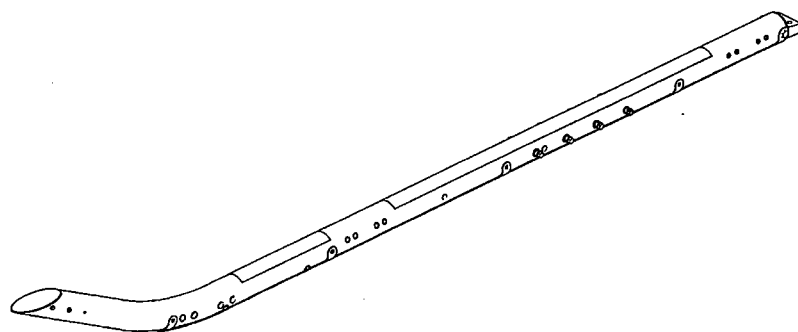
GENERAL NOTES:

- 1) MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

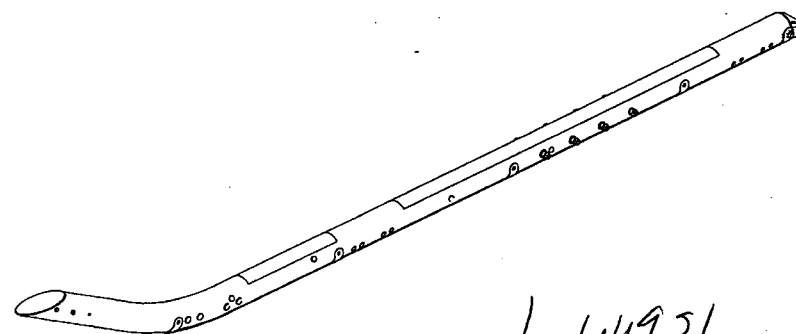
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WITHOUT NOTICE
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NO. 44951
10-81-4

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A	NEW ISSUE	SC	10.08.09
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DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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D4168-041 350 SKIDTUBE ASSEMBLY, LH

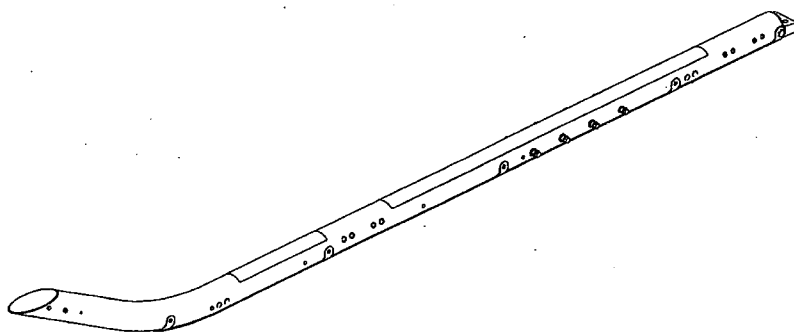


D4168-042 350 SKIDTUBE ASSEMBLY, RH

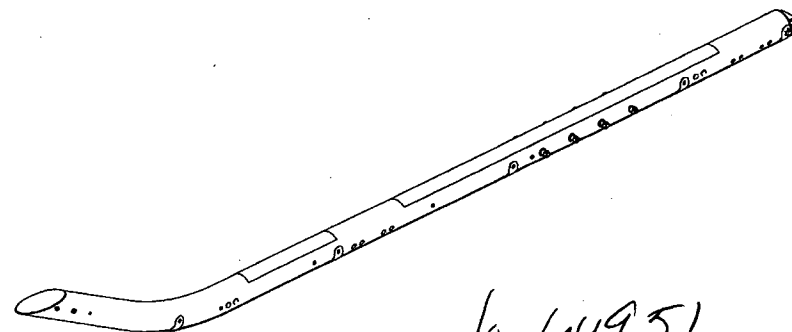
u10 44951

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JAM

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D4168-043 350 SKIDTUBE ASSEMBLY, LH

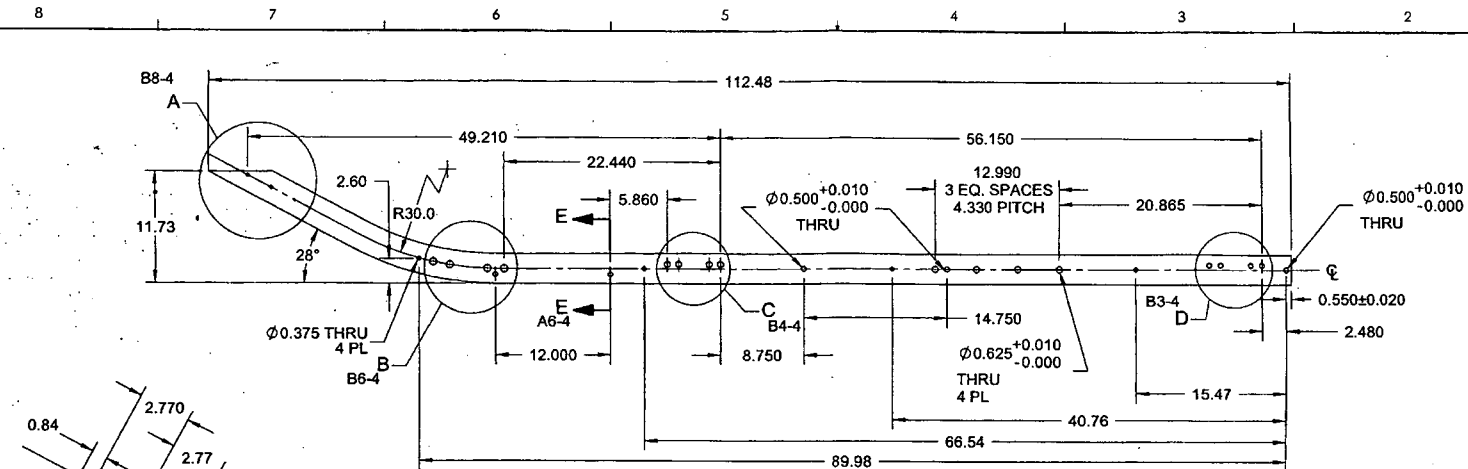


D4168-044 350 SKIDTUBE ASSEMBLY, RH

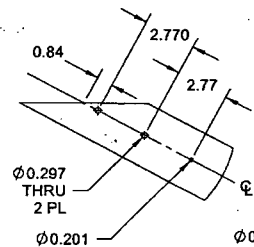
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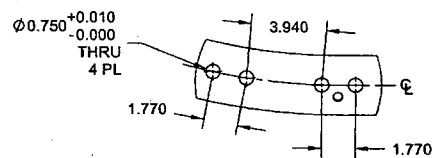
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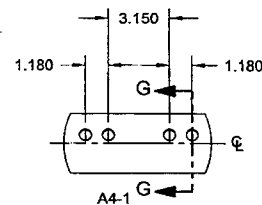
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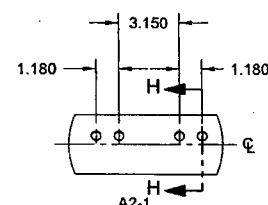
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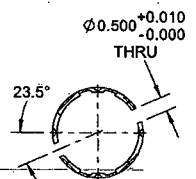
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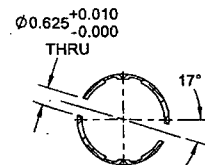
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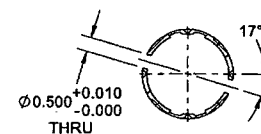
DETAIL D
SCALE 2X



SECTION E-E
SCALE 3X, 2 PL



SECTION G-G
SCALE 3X, 4 PL



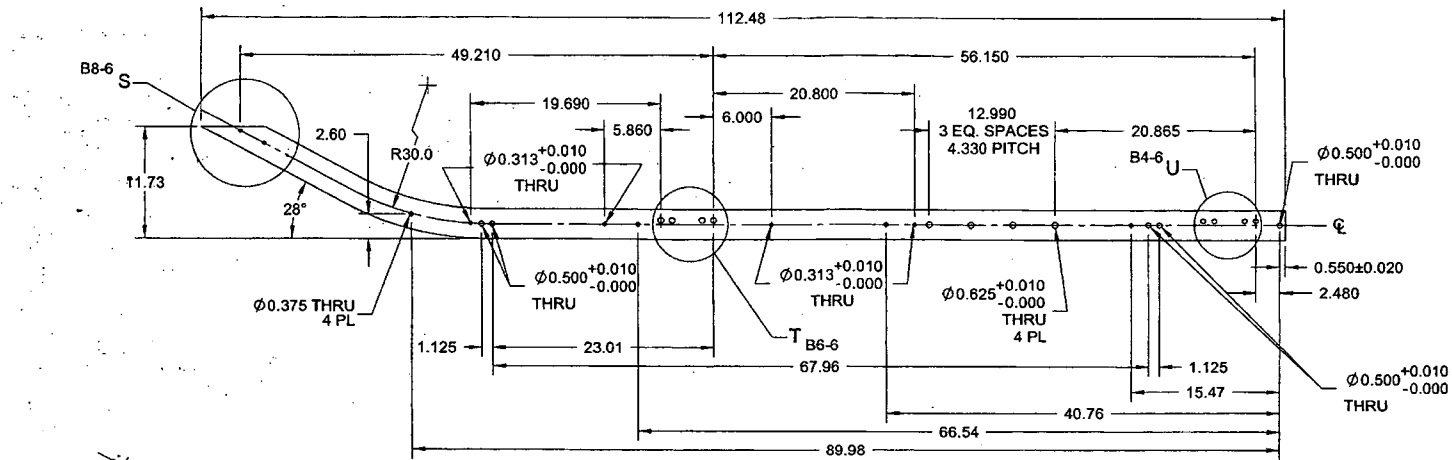
SECTION H-H
SCALE 3X, 4 PL

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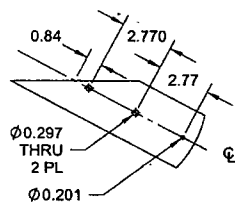
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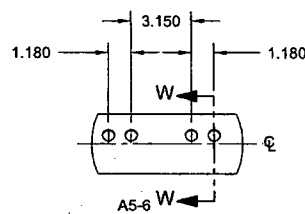
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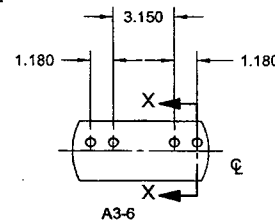
D4168-3 LH SKIDTUBE



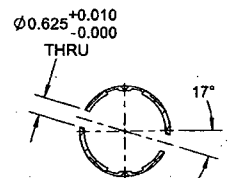
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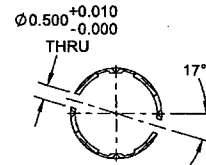
DETAIL T
SCALE 2X



DETAIL U
SCALE 2X



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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8 7 6 5 4 3 2 1

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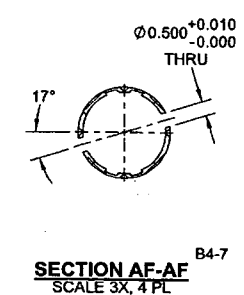
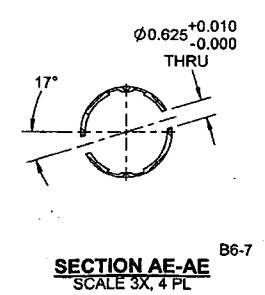
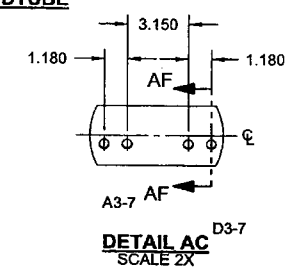
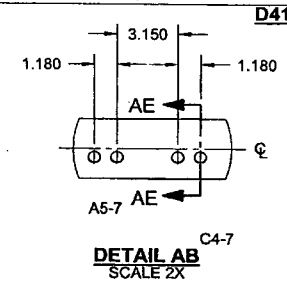
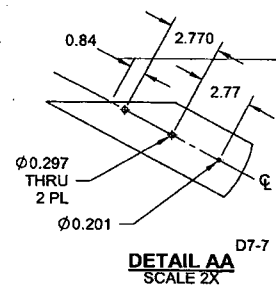
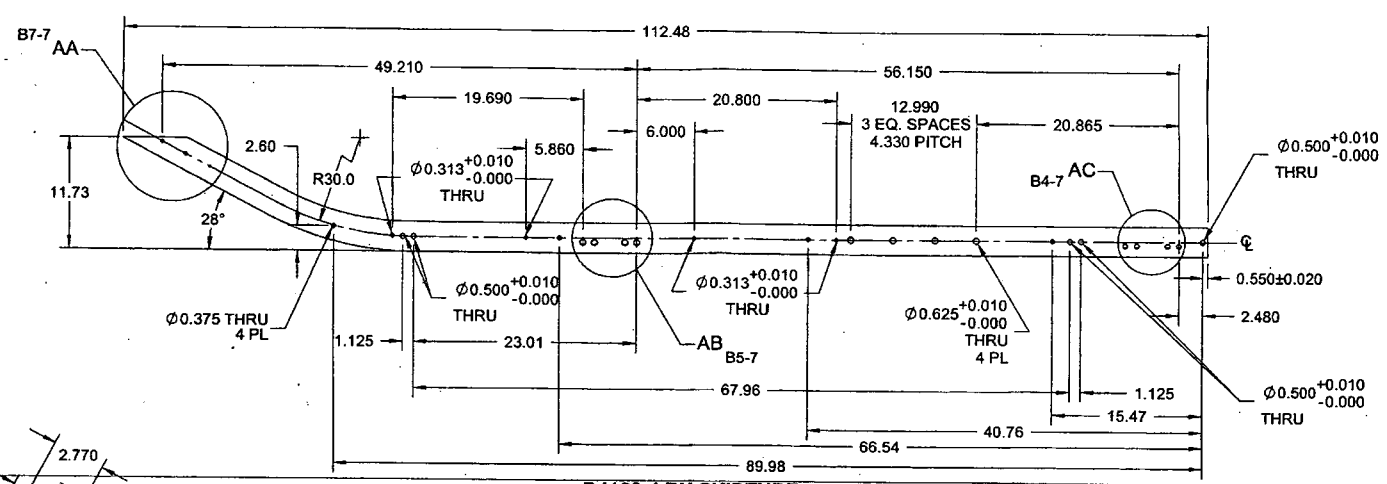
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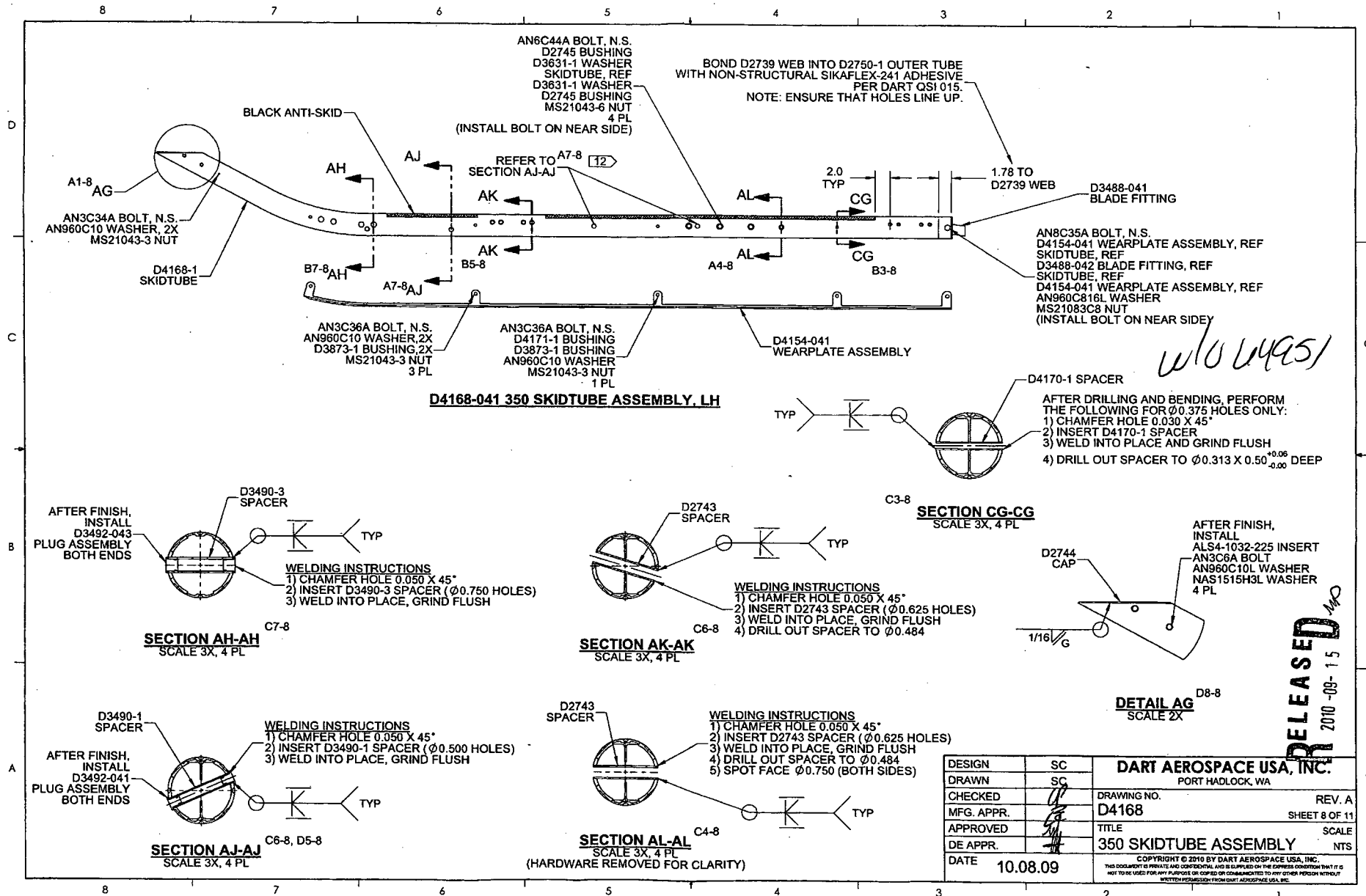


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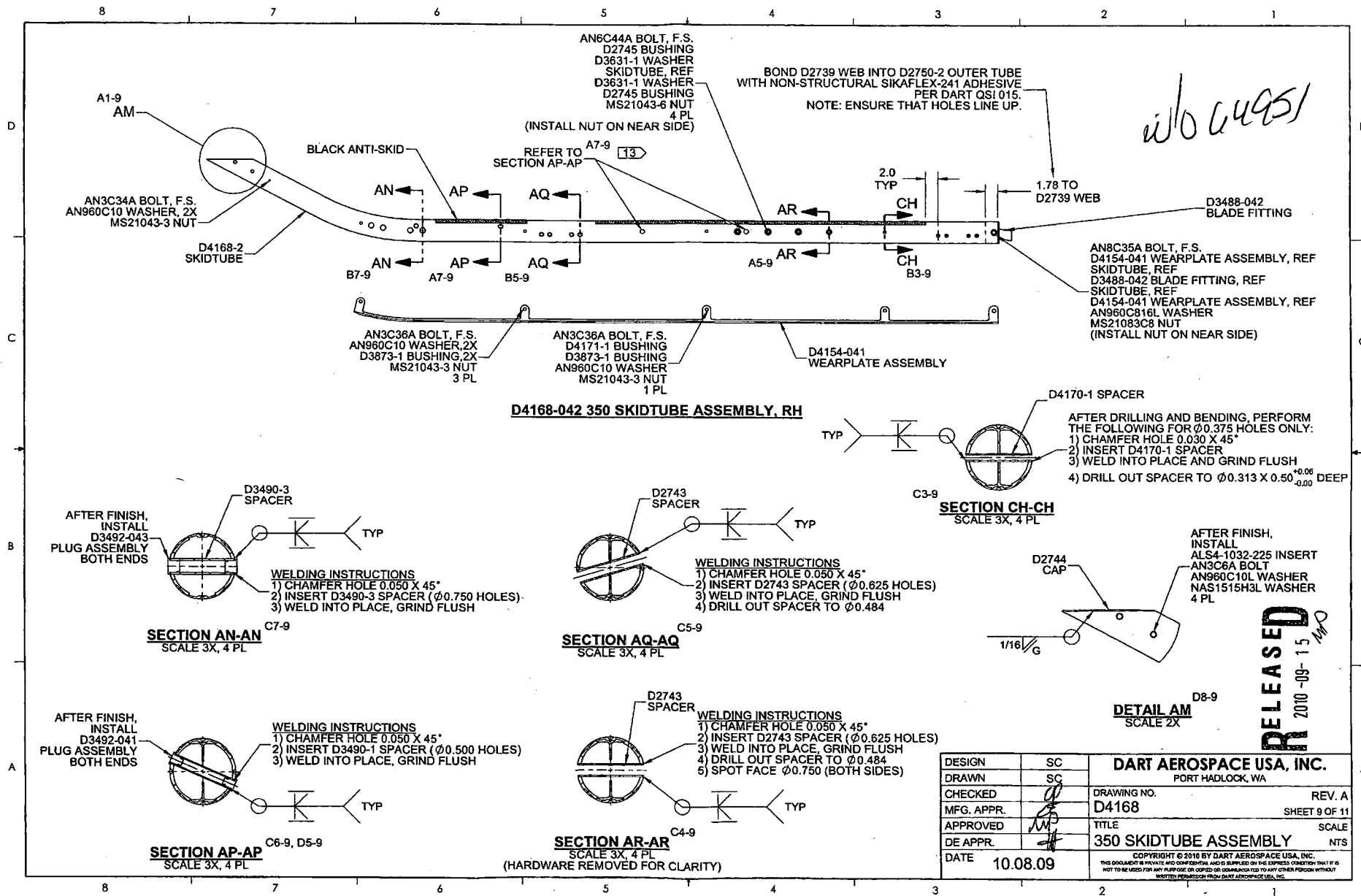
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8 7 6 5 4 3 2 1



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2010-09-15



NO. 243

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barkley Elliott
Job number: ~~64950~~ 64953
Part number: J 350-636-016
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Jack Lewis Date of Test Coupon 11-01-18
Welder Barkley Elliott Date of Test Coupon 11-01-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld